

Work Order ID 50047

July 7, 2009 7:45:18 AM

Page 1

Item ID: D350-567-111

Accept

Setup Start

Revision ID: D

Stop

Item Name: Floor Window Installation, Extra Large

Start Date: 7/08/09

Start Qty: ~~4.00~~ 3.0

Cust Item ID:

Required Date: 7/10/09

Req'd Qty: ~~4.00~~ 3.0

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev D

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels and DT8439 Template per PPP D350-567-111 CHG004

110

0.00



Packaging

Packaging

Packaging

Memo

Pick Packing Kit***ENSURE DT 8439 TEMPLATE IS INCLUDED***

120

0.00



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

0.00

8/1/09

Rev E

9/7/09

SD

34

8/1/09

83

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Page 2

Item ID: D350-567-111

Accept

Setup Start

Revision ID: D

Stop

Item Name: Floor Window Installation, Extra Large

Start Date: 7/08/09 Start Qty: 4.00

Cust Item ID:

Required Date: 7/10/09 Req'd Qty: 4.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-567-111 Location: <u>23</u>								
140 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

Rev 9

9/8/17 (3x) SE

09609603 JH

MK

09-09-02

Picklist Print

July 7, 2009 7:45:18 AM

Page 1

Work Order ID: 50047

Parent Item: D350-567-111RevD

Parent Item Name: Floor Window Installation, Extra Large




Comments:

Start Date: 7/08/09

Required Date: 7/10/09

Start Qty: 4.00 -1

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D350-567-113RevD 		Manufactured	No			120	Each	0.0000	4.0000			
Replacement Window, Extra Large												
D350-567-115RevD 		Manufactured	No			120	Each	0.0000	4.0000			
Interior Floor Window												
DT8439 		Manufactured	No			120	Each	0.0000	4.0000			
template												

3XSP

50048 21

50049 SP

9/7/7

SK
SC

Work Order ID 52664

October 6, 2009 8:43:59 AM



Page 1

Item ID: D350-567-111
 Revision ID: D
 Item Name: Floor Window Installation, Extra Large
 Start Date: 10/06/09 Start Qty: 6.00
 Required Date: 10/06/09 Req'd Qty: 6.00
 Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D350-567

Rev D

100

0.00



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy bluefile and create labels and DT8439 Template per PPP D350-567-111 CHG006

8/2/10/07

W

110

0.00



Packaging

Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

D350-567-111 B ~~4761~~ 48679

B ~~5124~~ 50047

REMOVE D3290-041 WINDOW

→ REMOVE FRAME AT .040 THICK AND REWORK/REPLACE FRAME WITH D3290-1 FRAME REV C-1

SSAO 09-10-06 6

Work Order ID 52664

October 6, 2009 8:43:59 AM



Page 2

Item ID: D350-567-111
Revision ID: D
Item Name: Floor Window Installation, Extra Large
Start Date: 10/06/09 Start Qty: 6.00
Required Date: 10/06/09 Req'd Qty: 6.00
Reference:

Accept



Setup Start



Stop



Cust Item ID:
Customer:

Approvals: Process Plan: Date:
QC: Date:

Tooling: Date:
SPC (Y/N): Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 802/10/17

16

4

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

2) 802/10/17

16

4

130

Packaging

0.00



Packaging

Memo

0.00

Packaging

Rev 2

9/10/17 16 51

REPACKAGE PER PPP USING NEW B/N, NEW LABELS REQUIRED @
CHG 006
(CHG 003 FOR THE D350-567-113)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.10.07	130	D350-567-111 @ CHG 006 D350-567-113 @ CHG 003 KIT ACCEPTABLE BASED ON CP-ACCEPTED DEVIATION OF D350-1 FRAME				CP 09.10.07 PC QSI/ULZ	S 02/01/07

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-567-111

Revision ID: D

Item Name: Floor Window Installation, Extra Large

Start Date: 10/06/09 Start Qty: 6.00

Required Date: 10/06/09 Req'd Qty: 6.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Accept



Setup Start



Stop



Cust Item ID:

Customer:



09/10/07

W 09.10.07

Picklist Print

October 6, 2009 8:43:58 AM

Page 1

Work Order ID: 52664



Parent Item: D350-567-111RevD



Parent Item Name: Floor Window Installation, Extra Large

Start Date: 10/06/09

Required Date: 10/06/09

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3290-041RevC		Manufactured	No				Each	2.0000	6.0000			



Replacement Window Assembly



SAD 09-10-06

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

ST219

2

51241

2

47611

4

52643

x 2

4

x 6

D350-567-111

3 x 50047

3 x 48679

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1			D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	1/4 TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
		9	8		AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
		9	8		AN960JD6	WASHER
		9	8		MS21042L06	NUT (OR MS21042-06)
		2	40		MS20470AD4-5	RIVET
		115	90		MS20470AD4-6	RIVET
		15	20		MS20470AD4-7	RIVET

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Revision: D

Date: 08.07.08

79664

DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN 92	CHECKED	MFG. APPR.		APPROVED		DE APPR.	
DATE 09.09.18	DATE	DATE		DATE		DATE	

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

52664

09.10.07

RTF ONLY

**PRELIMINARY
ISSUE**

09.10.05

ENGINEERING CHANGE NOTICE **DART AEROSPACE LTD**

Date: 09.10.05	Job No.: ENG0106OCT	ADR Yes/No: N	ADR Date: N/A	ECN #: 09- 683P
Product No.: D350-567	Created By: CP	Approved By:		
Product Name: Vert Ref Window	Checked By:	General Manager Approval:		

Distribution	Reqd	Resp	Initial / Date
Production Manager	Y	DL	
Production Engineering Coord	Y	DD	
Production Document Control	Y	BG	
Customer Technical Support	N		

Distribution	Reqd	Resp	Initial / Date
DQA / QA Coord	N		
QC Coordinator	Y	JM	
Marketing	N		
Customer Order Processing	Y	SB	

Reason for Change:

Release DEO to allow preliminary manufacture of D3290-1

Documents Affected:

Release

DEO-D3290-C-1, Preliminary Issue

PARTS MUST COMPLY

☐

PREVIOUS PARTS SATISFACTORY

☒

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Product Compatability Matrix	N			
6	Create Eurocopter Form (FEE)	N			
7	Notify TC / FAA of Change	N			

#	Document Control Actions	Reqd	Resp	Notes	Complete
8	Move Electronic Files	N			
9	Update Blue/Pink/DSI Folder and Electronic Files	N			
10	Update Controlled PDF Files	N			
11	Update Master Document List (MDL)	N			
12	Update Document Record (DR)	N			
13	Update Product Development Summary	N			
14	Update QSI 021 and/or STC Approval List	N			
15	Update Parts / STC Database	N			
16	Update / Verify ARC Database	N			
17	Create / Update Change Record Form	NY			
18	Create / Update PPP's	NY			
19	Update Document Control Database / Laminated Dwgs	N			
20	Update Grey Project Binder	N			
21	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
22					
23					

Description / Action:

- DEO-D3290-C-1 is released as preliminary, to amend D3290 Rev. C

- D3290-1 frame now 0.063" thick

- Need qty(1) D3290-041 Replacement Window Assembly with thicker D3290-1 ASAP for shipment of D350-567-111

- With thicker frame, D350-567-111 will be CHG 006, -113 @ CHG 003, -117 @ CHG 002

- DEO WILL BE RELEASED SHORTLY WITH INSTRUCTIONS TO REWORK ALL AFFECTED STOCK

New-52643 Rework- 52664

ECN Verified & Complete: _____

Date: _____